

Date: Tuesday, 10/23/2007 3:11:05 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 35328	
Estimate Number : 10260	
P.O. Number : <i>N/A</i>	Part Number : D23623
This Issue : 10/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 34292	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/25/2007 Qty: <i>15</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: G 00-05.18 Added inspection level 8 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Step Support  
Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	<i>29807</i>

*7/07-11-1 (15)*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

*J.L 07/11/28*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

*J.L 07/11/28*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*2F 07/12/02*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

*SB 07/12/04 (15)*

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

*FX 07/12/04 (15)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/12/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 35328

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(SX)

Comment: INSPECT POWDER COAT

M-L

07/12/04

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1 D2397-1

Rubber

B30971

X 13mx

B 36/17

x 2mx

mf

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1 D2397-3

Rubber

B30972

x 13mx

B 26/18

x 2mx

mf 07-12-07

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch

M102505

mf 07-12-10

(15)

11.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

07/12/10

(15)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST478

W

07/12/10

(15)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/11

Job Completion



W 07/12/11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

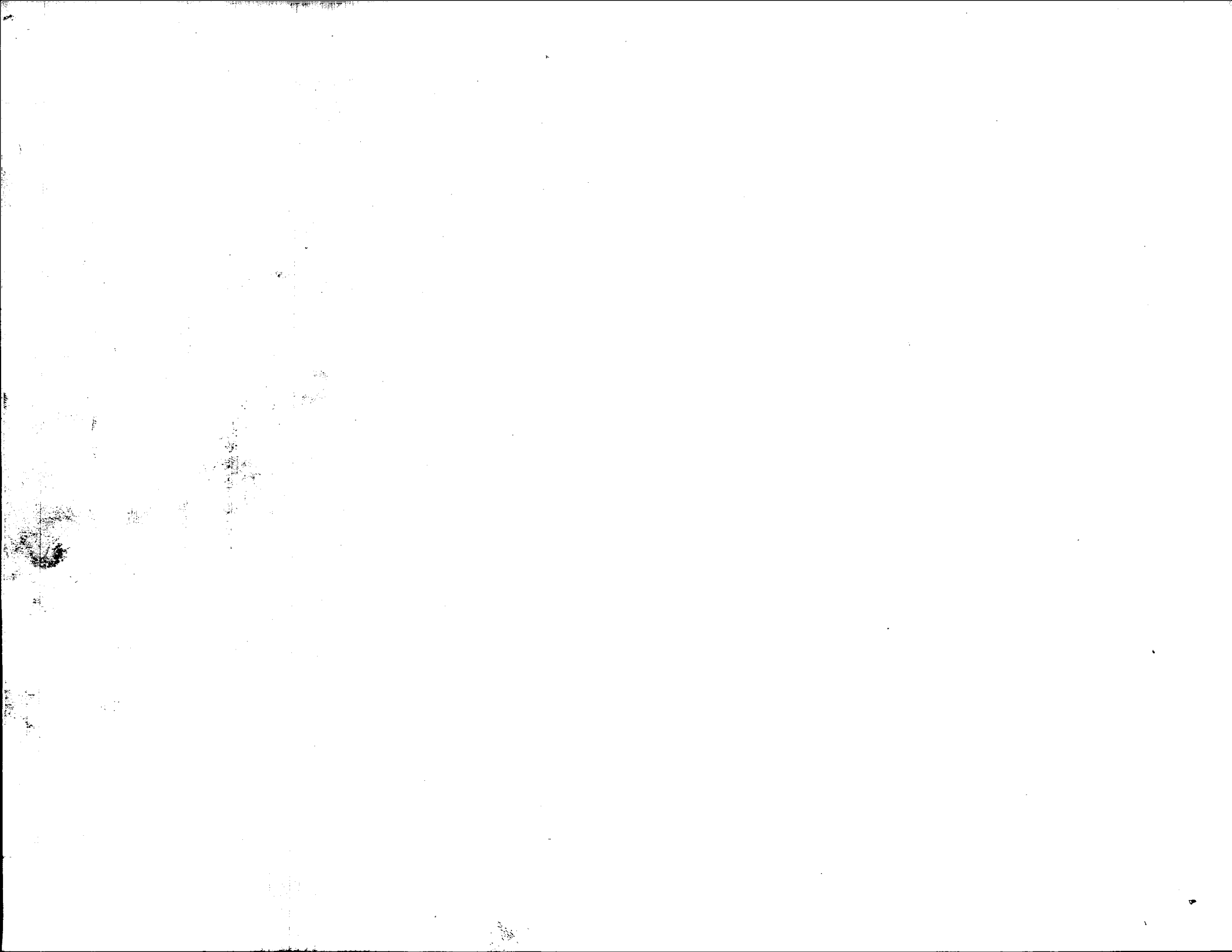
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**DART**



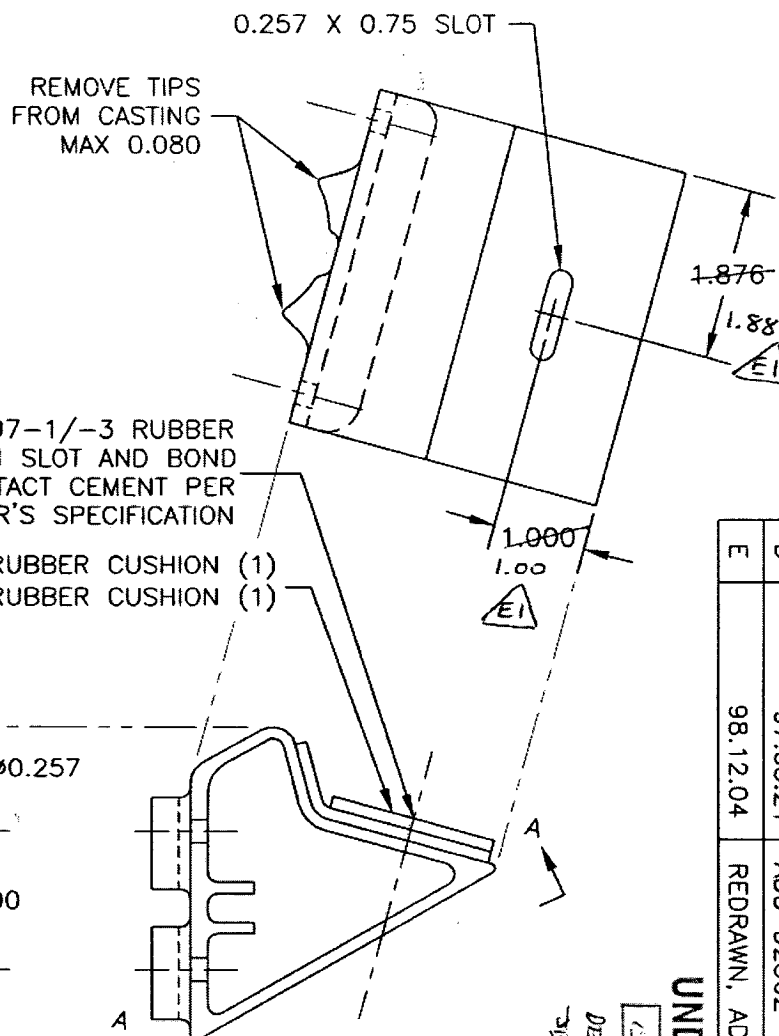
**RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

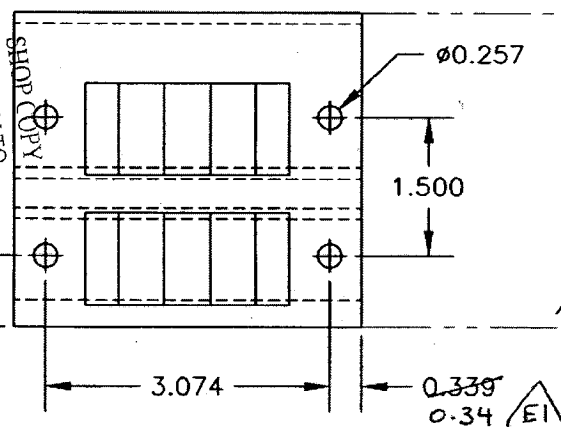
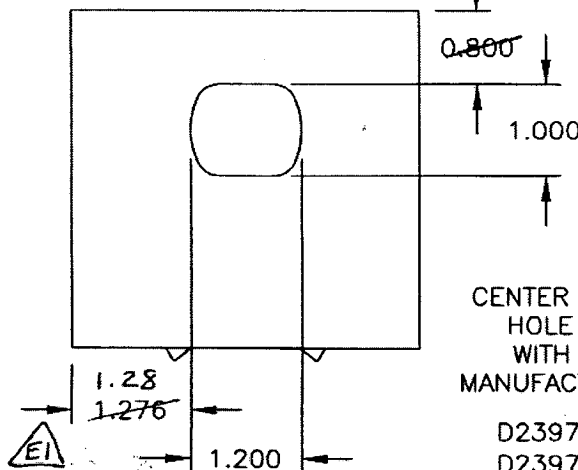
**UNDER REVIEW**

03.03.15 CP

DESIGN OK, BUT CHECK WITH  
3/3 BEFORE MANUFACTURE  
OK 04/11/09



VIEW A-A



**NOTES:**

MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

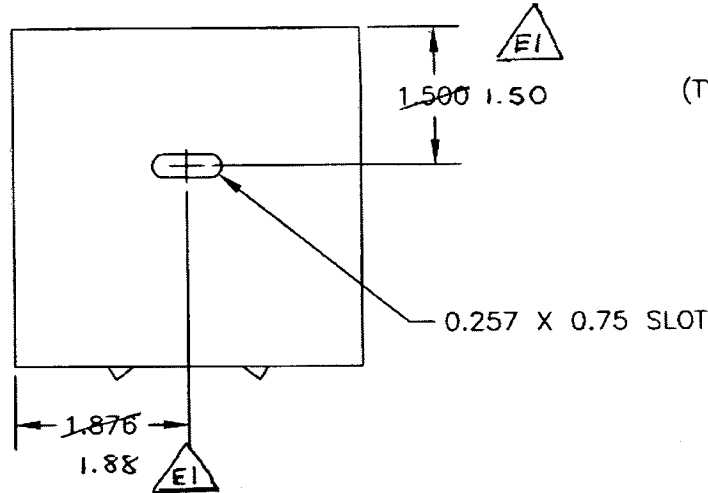


DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE 1:2

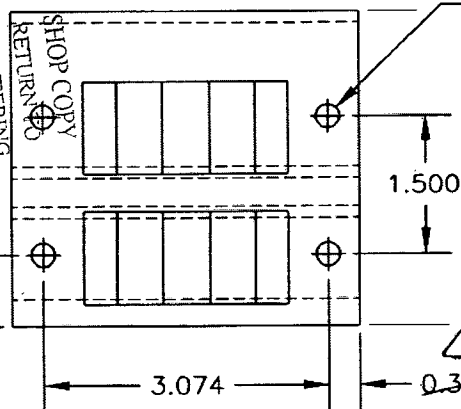
**RELEASED**  
98.12.14 KE  
**UNDER REVIEW**

DESIGNED, BUT CHECK BY  
DR BERGE MANUFACTURE  
OK CP 4/1/05

VIEW A-A



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE



D2362-1 & D2362-5

BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

**NOTES:**

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2362-041 (SHOWN)

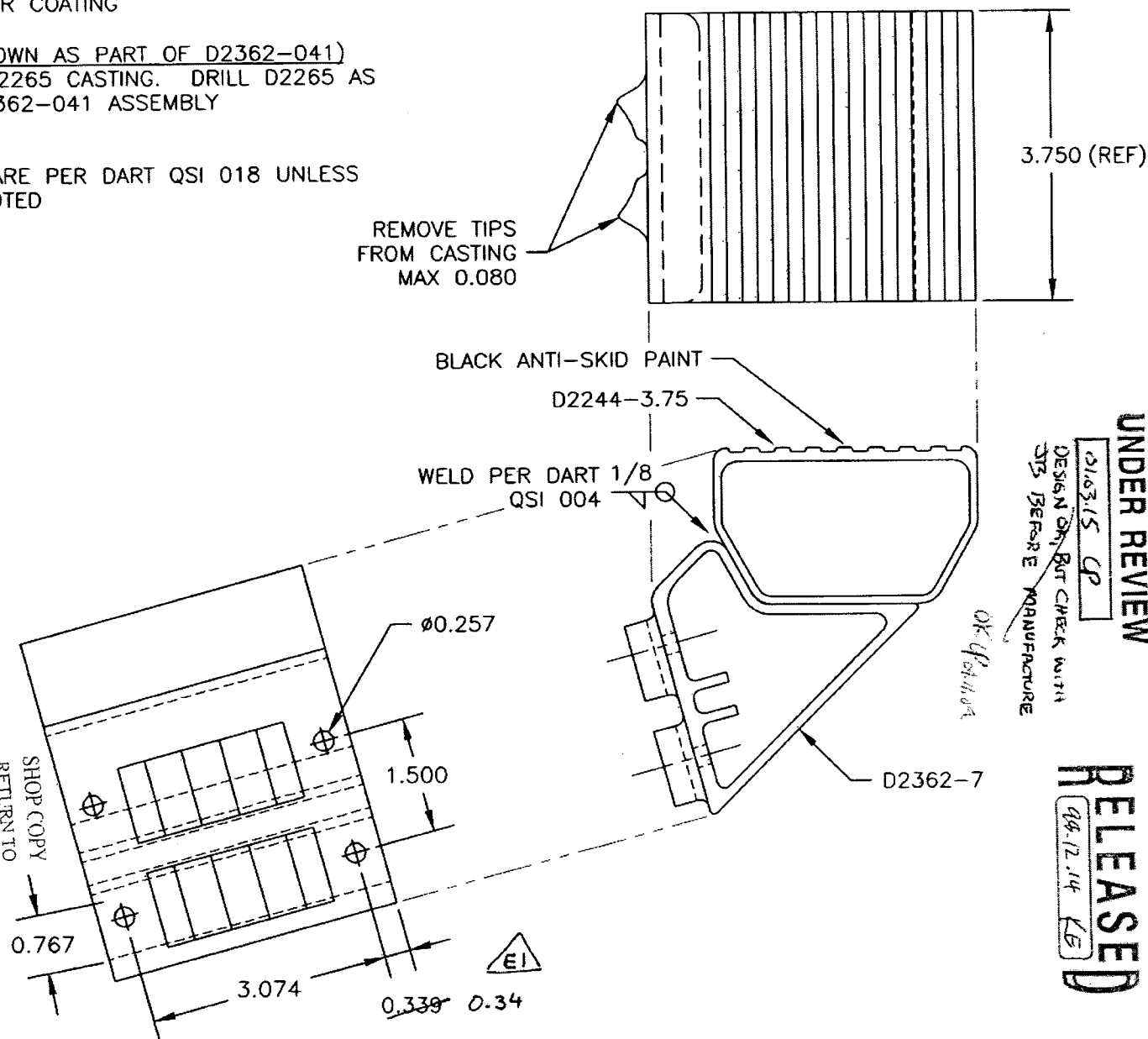
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE 1:2

UNDER REVIEW

RELEASED

01.03.15 CP  
DESIGN OK BUT CHECK WITH  
DTS BEFORE MANUFACTURE

OK 4/11/04